

Date: Monday, 6/19/2006 11:30:45 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING		
Job Number	: 27645		Part Number	: D312123		
Estimate Number	: 10089		Drawing Number	: D3121 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 6/19/2006	S.O. No. : N/A	Drawing Revision	: D		
Prsht Rev.	: NC	Type : PURCHASED PARTS	Material	: N/A		
First Issue	: N/A		Due Date	: 6/26/2006 Qty: 100 Um: Each		
Previous Run	: 26936					
Written By	: <u>SPJ</u> COMMENT Below					
Checked & Approved By	: <u>SPJ</u> 06.06.19 W					
Comment	: Est. A: 04.02.19 New Issue KJ/DS					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		Comment: PURCHASING Issue P/O: <u>1511</u> C Low 19/06 100 Bearing as per Dwg D3121 Possible Supplier: SKF P/N: 61900-2Z or KML P/N: 6900-ZZ Material release note is required
2.0	6900ZZ	Bearing 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Bearing
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK 
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3121 and attached certification Dwg Rev <u>D</u> 
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>SI</u> 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: 

Date: 06/06/21

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:30:45 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING

Job Number: 27645

Part Number: D312123

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

100  
100/06/121

Job Completion



Wade 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

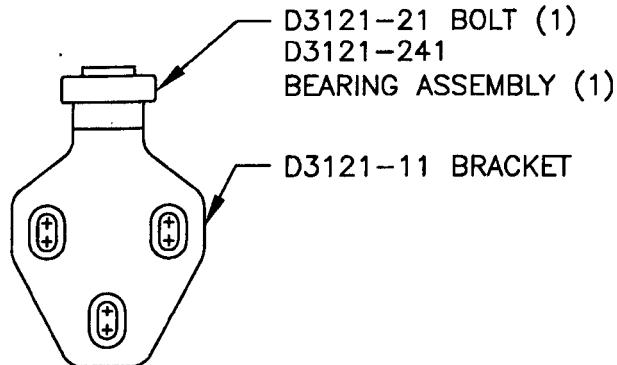
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

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CHECKED	APPROVED	DRAWING NO. D3121 REV. D SHEET 1 OF 10
DATE 06.05.17	TITLE BRACKET ASSEMBLY SCALE 1:2	

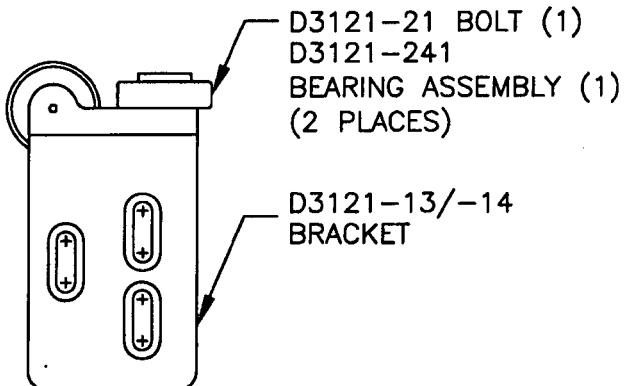
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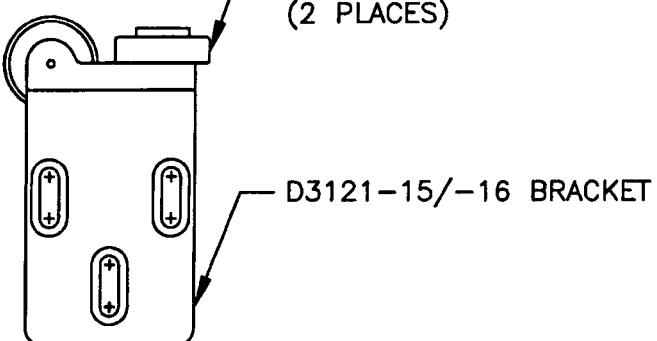
D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

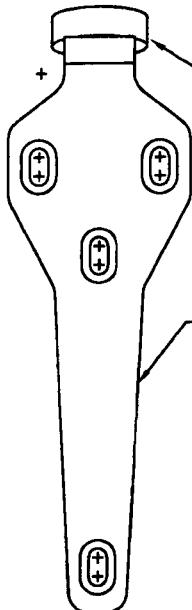
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06.05.17		TITLE	SCALE
		BRACKET ASSEMBLY	1:2



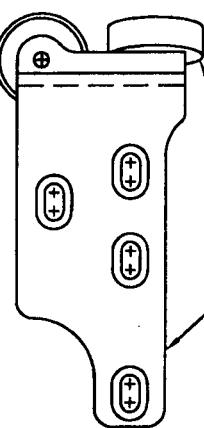
D3121-21 BOLT (1)  
D3121-241  
BEARING ASSEMBLY (1)

**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

D3121-111 BRACKET

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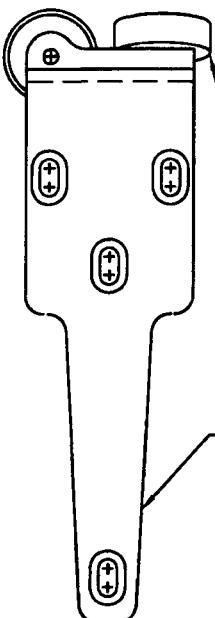
06.06.02 *[Signature]*



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)  
D3121-241 BEARING ASSEMBLY (1)  
(2 PLACES)

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

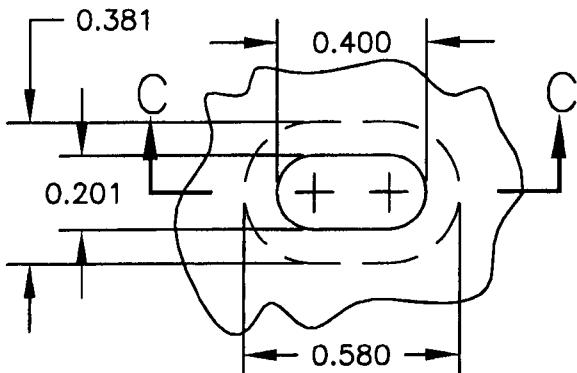
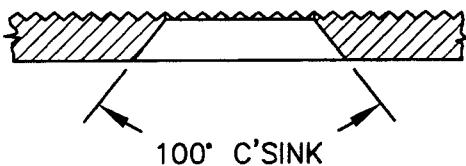
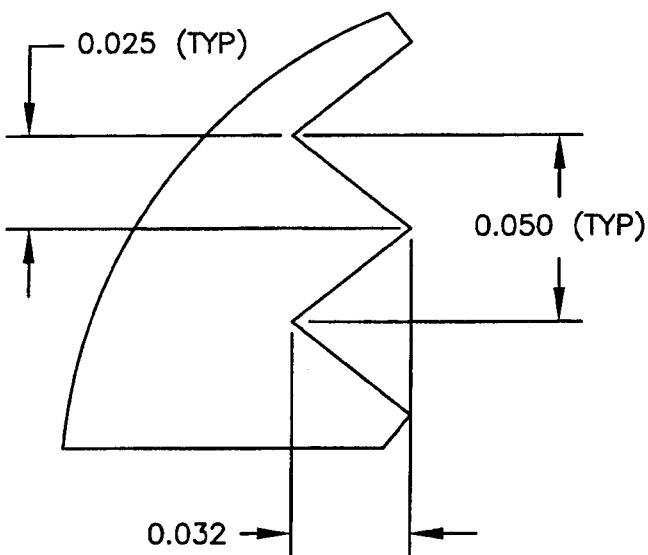
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DATE 06.05.17		TITLE BRACKET ASSEMBLY SCALE 1:1

**DETAIL A:  
SLOT DETAIL**SCALE 2:1  
VIEW ROTATED**SECTION  
C-C****DETAIL B:  
RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20

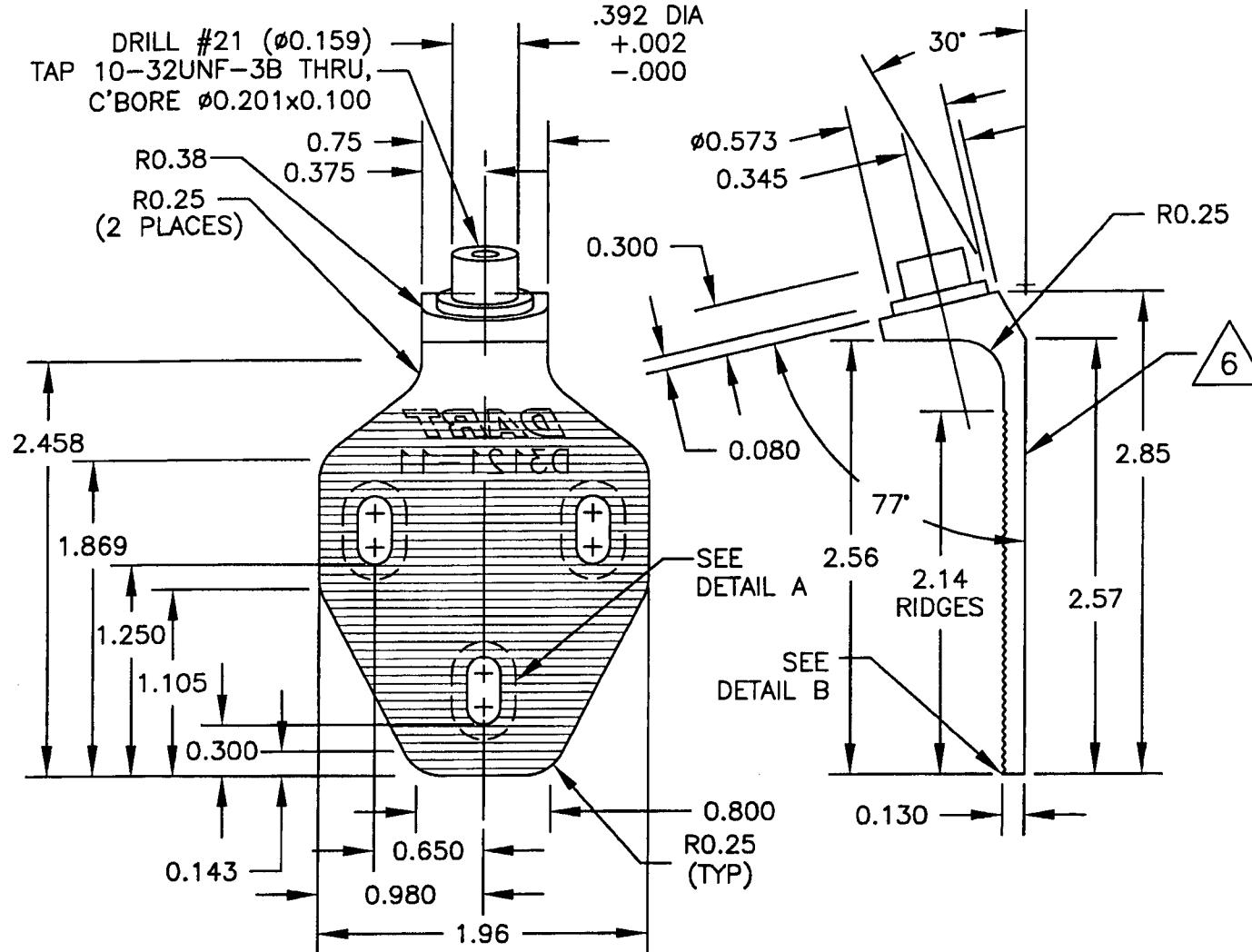
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S. J. H.	M. H.	D3121	SHEET 4 OF 10
DATE	TITLE	SCALE	1:1
06.05.17	BRACKET ASSEMBLY		

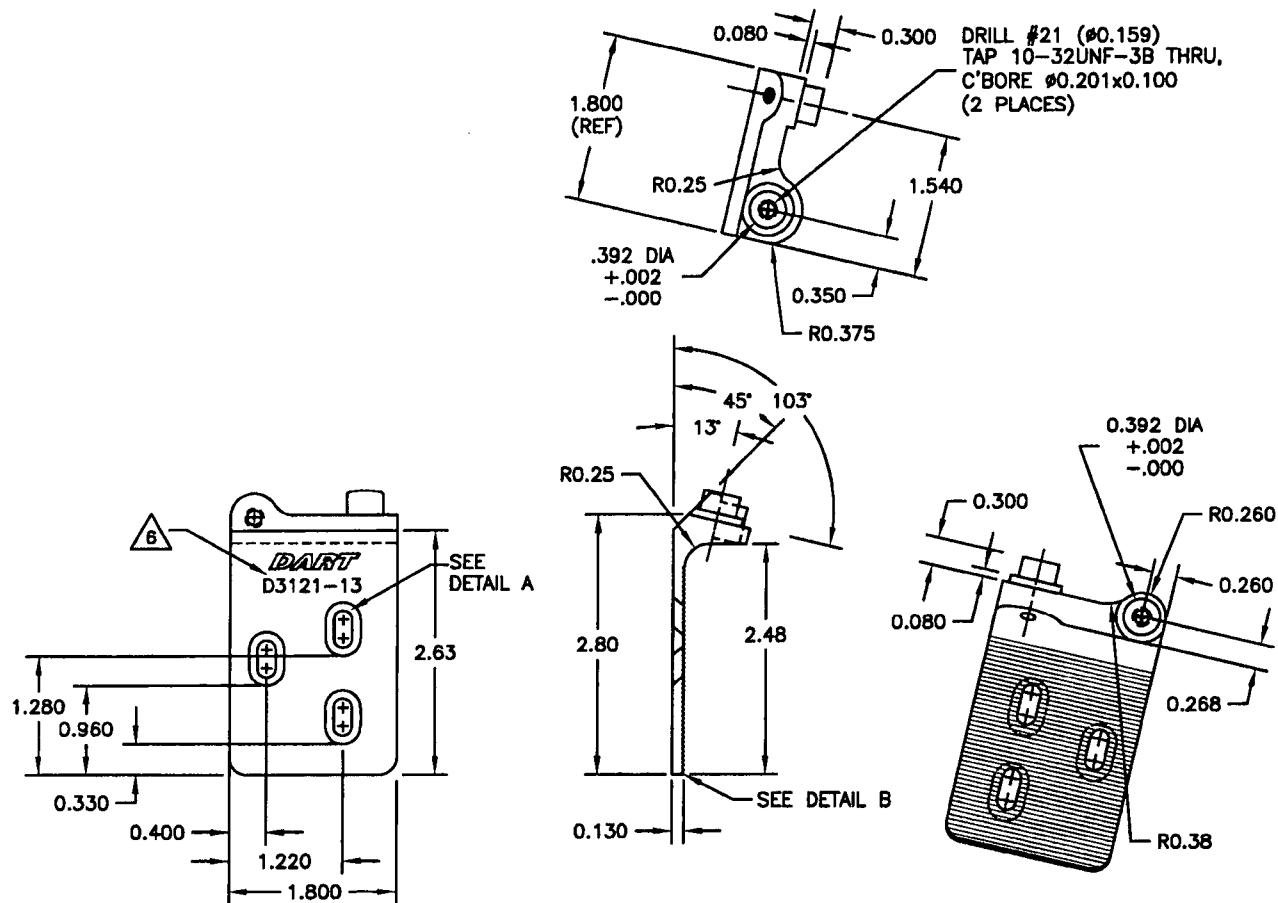
**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE	06.05.17	REV. D SHEET 5 OF 10 TITLE: BRACKET ASSEMBLY SCALE: 1:2

**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

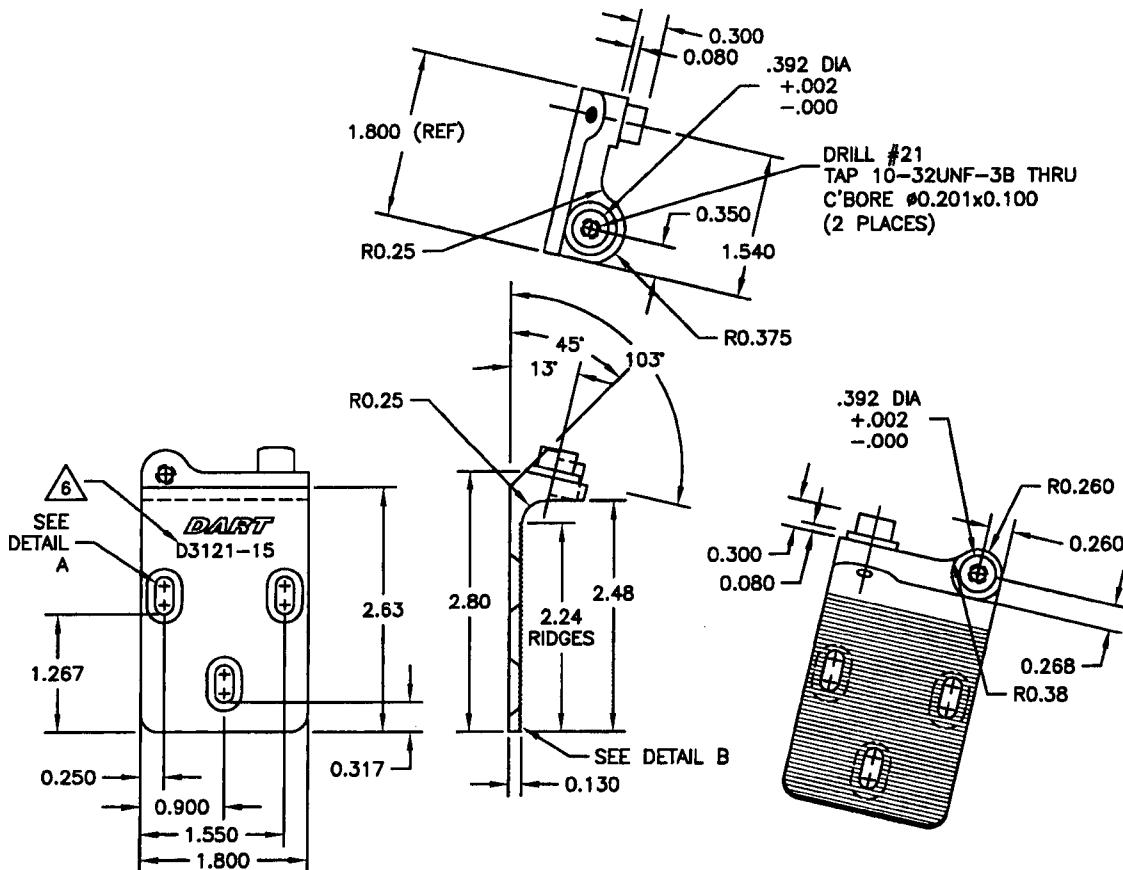
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DATE	06.05.17	TITLE	SHEET 6 OF 10 SCALE 1:2



**D3121-15 BRACKET (SHOWN)**  
**D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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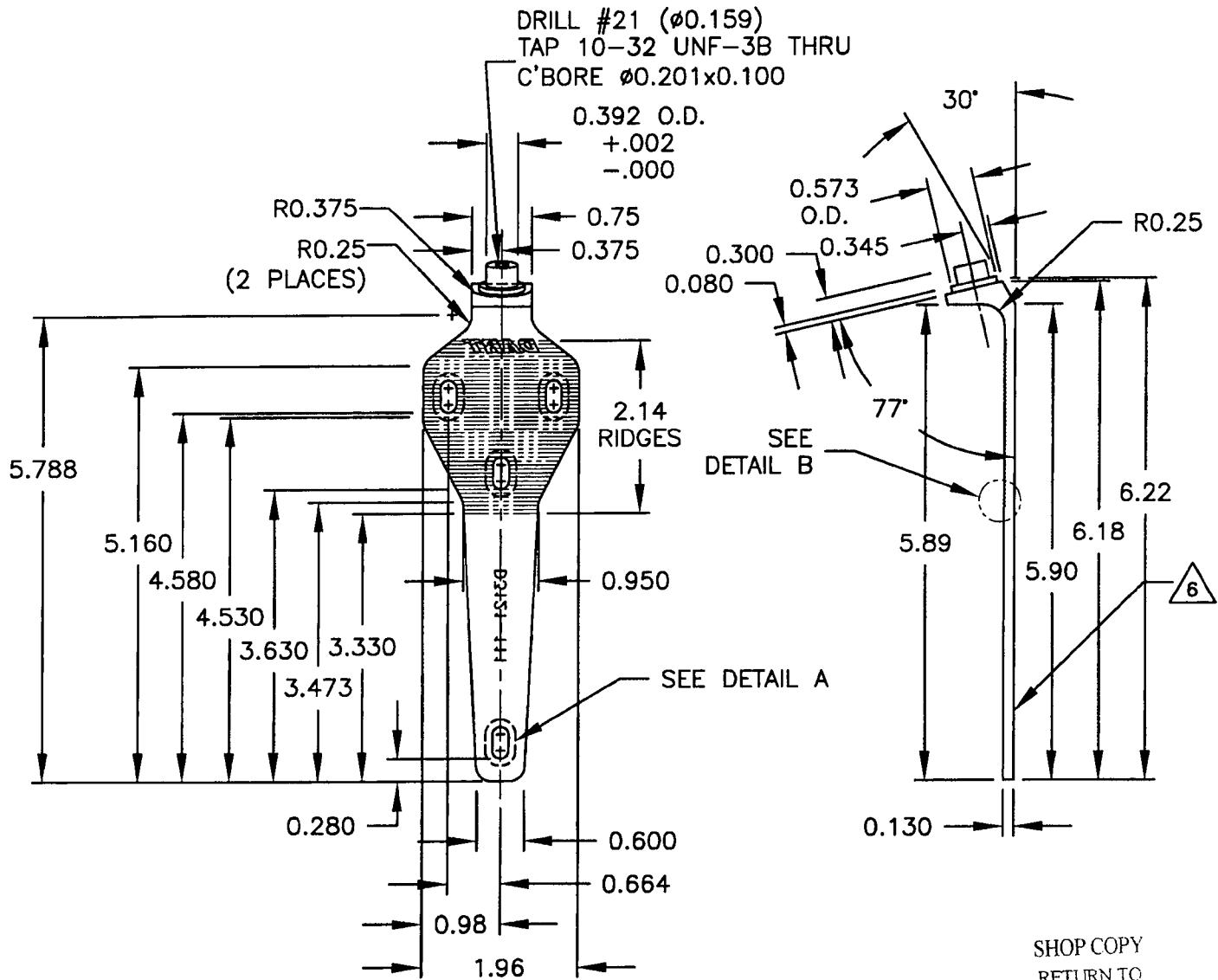
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DATE 06.05.17	TITLE BRACKET ASSEMBLY	SCALE 1:2	



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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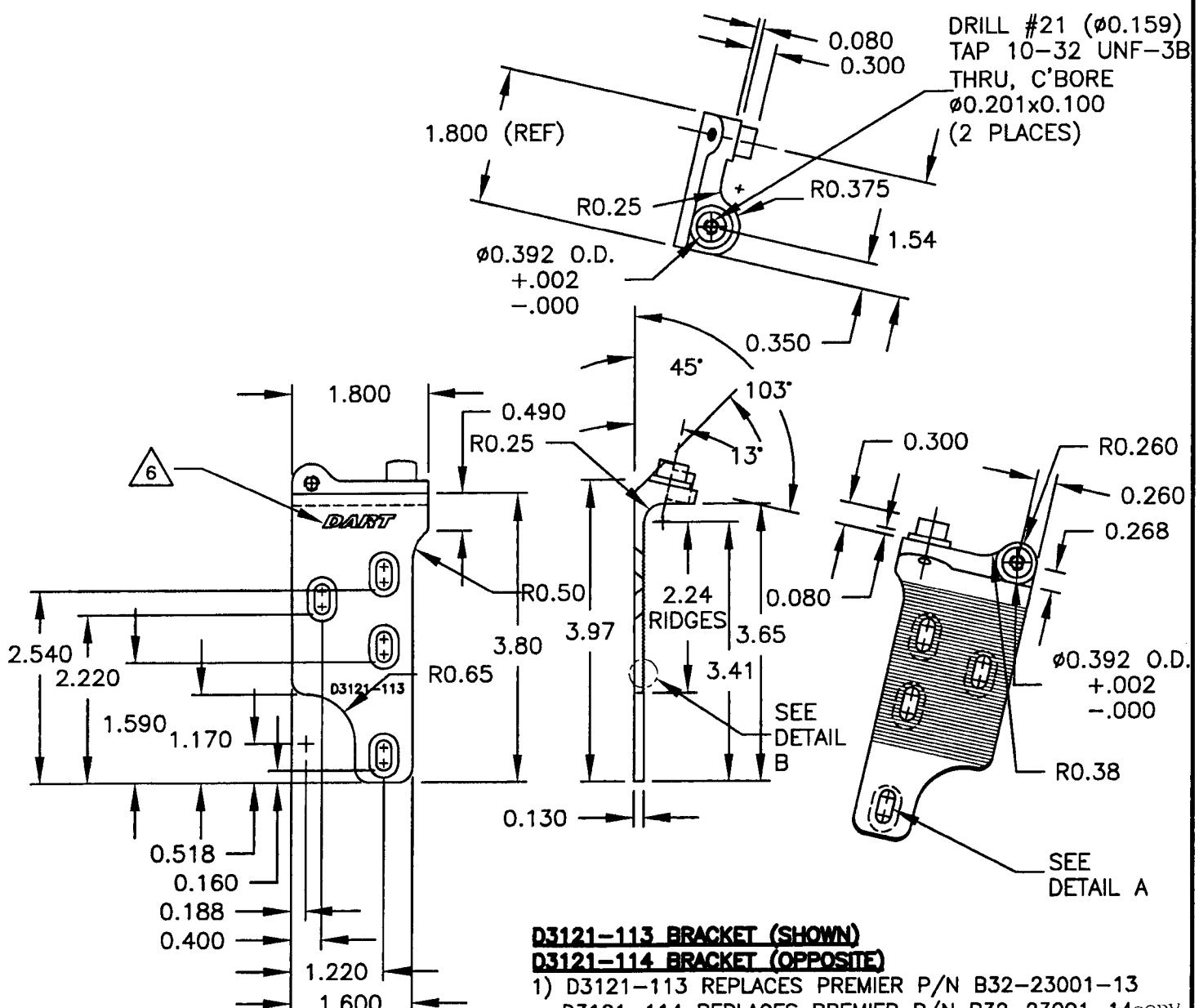
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SHEET 8 OF 10	DATE	TITLE	SCALE

06.05.17

BRACKET ASSEMBLY

1:2

**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14 COPY  
SHUT DOWN
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi  
CONTROLLED COPY
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS SUBJECT TO AMENDMENT  
OTHERWISE NOTED  
WITHOUT NOTICE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN  
NO. 27645 WORK ORDER
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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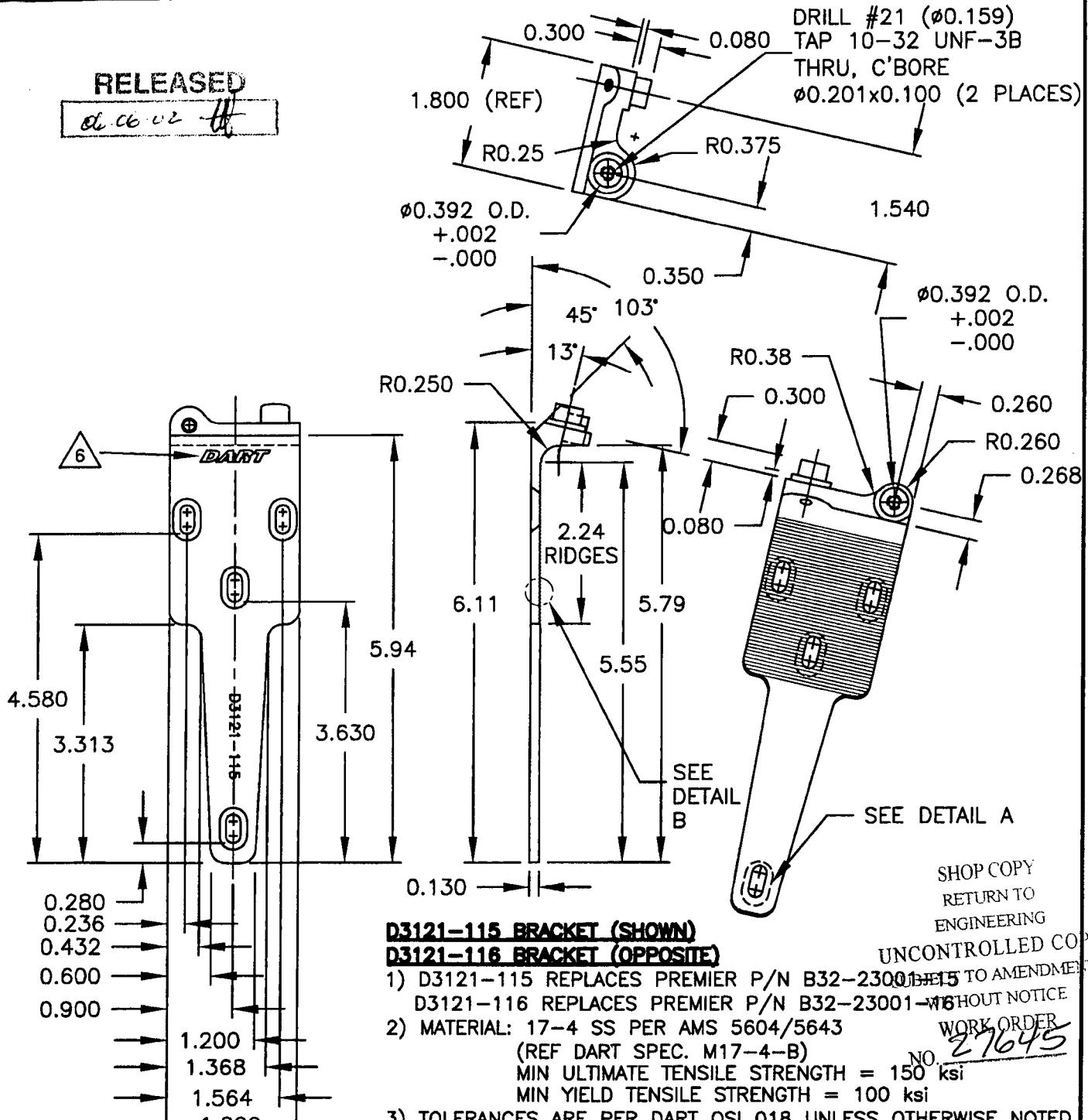
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		D3121	SHEET 9 OF 10
DATE	TITLE	SCALE	
04.02.18	BRACKET ASSEMBLY	1:2	

RELEASED

06.02.18

**D3121-115 BRACKET (SHOWN)  
D3121-116 BRACKET (OPPOSITE)**

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-BEL5 TO AMENDMENT D3121-116 REPLACES PREMIER P/N B32-23001-W16 WITHOUT NOTICE
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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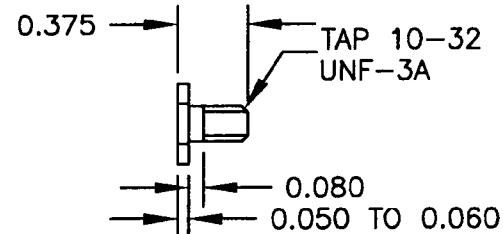
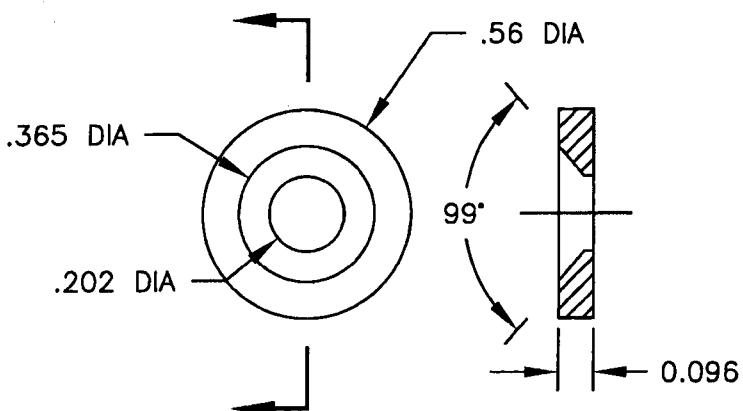
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WORK ORDER  
*27645*

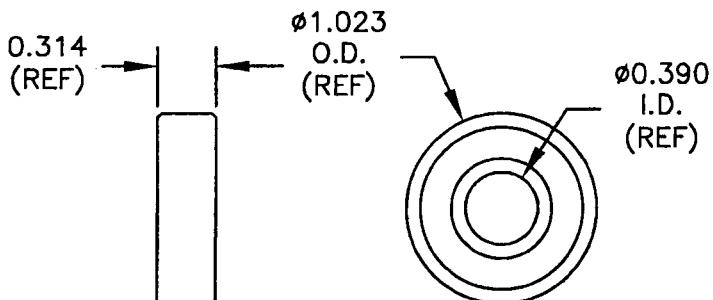
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DATE		REV. D SHEET 10 OF 10 TITLE BRACKET ASSEMBLY SCALE 1:1

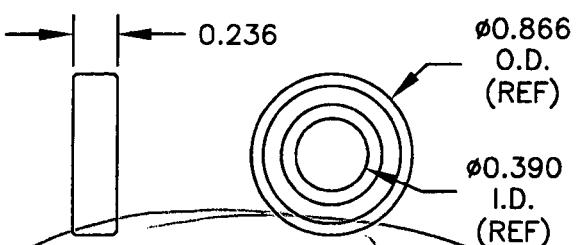
06.05.17

**D3121-17 WASHER (SCALE 2:1)**

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

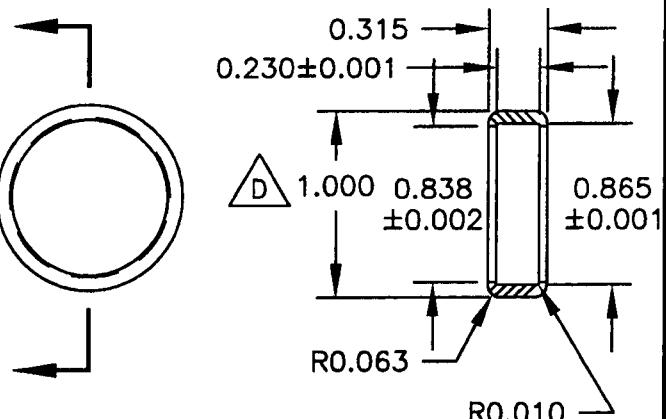
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

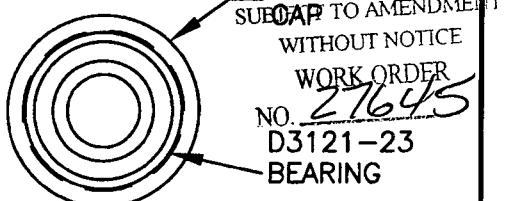
**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

# GENERAL BEARING SERVICE

INC.

www.gbs.ca

386 MAIN ST E, HAMMERSBURY, ONTARIO N0A 1M8 (613) 622-9914

GST # R101979084

SOLD TO: DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAMMERSBURY, ON  
N0A 1K7

SHIP MADE BY: DR  
SHIP VIA:

PRODUCT DESCRIPTION: SOLD SHIP PRIVATE EXTENSION

6900-22 BALL BEARING

POST LICENSE: 6122-5297

ORDER DATE: JUN 29, 2006

CUSTOMER ORDER #: 0000151

PROD. SUPP. NO: 134863-0

RECEIVED BY:

DOOR WAYS

DOOR WAYS